Work	Order	ID	61206
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Page 1

Wednesday, August 11, 2010 10:13:49 AM Item ID: D3502-1 Accept Setup Start Revision ID: Stop Item Name: Support **Start Qty:** 12.00 Start Date: 8/11/2010 **Cust Item ID:** Req'd Qty: 12.00 Required Date: 8/25/2010 **Customer:** Reference: Start Run Date:  $\{0 - \beta - \}\}$  Tooling: Process Plan: MF Approvals: Date: 🕶 Stop Date: \_\_\_\_ QC: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Reject Tool ID Tool # Plan Accept Reject **Work Center ID** Description Code Qty Oty Number Stamp **Run Hours Revision Nbr Draw Nbr** D3502 Rev B 100 0.00 2/10/08/22 **BAND SAW** Bandsaw Memo Jeaspa Bandsaw Cut blank 3.475 " long □ 1 BLANK MAKES 2 PARTS 110 HAAS CNC VERTICAL MACHINING #1 0.00 1- Mill as per Folio FA649 Rev: A & Dwg D3502 Rev: Per dwg D3502 HAAS CNC vertical machine #1 28,0/08/22 12 g QC2- Inspect parts off machine FAI/FAIB 0.00 0.00 Memo Quality Control

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CHAN	IGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No		PAR #:											
	R	esolution:	Disposition	:	QA: N	C Clos	sed:		Date: _				
NCR:			WORK ORDE	R NON-CONFORM	IANCE (I	VCR)							
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	Section B  Sign & Date			cation ion C	Approval Chief Eng	Approval QC Inspector			
<del></del>			O.M.O. E.N.G	Sillor Ling									
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Work Orde Wednesday, Augi													Page	2
Item ID: D3502-1  Revision ID:  Item Name: Support			A	Accept							Start Stop			=
	8/11/2010	Start Qty: 12.00 Req'd Qty: 12.00	1 1888 1818 188 188 1 1881 1884 188			Cust Item ID Customer:	:							
Approvals:		an:	Date:	Tooling: SPC (Y/		Date Date			1	Run	Start Stop			
Sequence ID/ Work Center ID  130 QC Quality Control	) .	Operation Description QC8- Inspect parts - secon	nd check	0.00	p/ Hours	Tool ID  10/08/24	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp	-
140				0.00					/2					

Small Fab

Small Fab

Memo Small Fab Mark hole position using DT9430□Drill as per Dwg D3502.

150

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

# **Dart Aerospace Ltd**

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W/O:			WO	RK ORDER CHANG	aES					
DATE	STEP	PRO	OCEDURE CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	_ NCF	t: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Disposition	:	QA:	N/C Cld	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	)			
DATE	OTED	Description of NC	Corrective Action Section B				Verifi	cation	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date		ion C	Chief Eng	QC Inspector
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#### Work Order ID 61206



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Wednesday, August 11, 2010 10:13:49 AM

Item ID:

D3502-1

Accept

Setup Start



Stop

Stop



**Revision ID:** Item Name:

**Start Date:** 

Support

Required Date: 8/25/2010

8/11/2010

**Start Qty: 12.00** 

Req'd Qty: 12.00

**Cust Item ID: Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Date: \_\_\_\_\_

Tooling: SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Tool # Plan

Code

Run Start

Reject

Qty

Accept

Qty



Number Stamp

Insp.

Sequence ID/ **Work Center ID** 

160

Powdercoat

Powder Coating

Operation **Description** 

White Gloss(Ref:4.3,5.1) per OSI005 4.3-Alum

MU5291

Memo

0.00

10:45 BOVEN TEMPERATURE:

Reject

170

Quality Control

QC3-Inspect Part Finish

Memo

Identify as per dwg & Stock Location

0.00

=7. H 10/08/27

180

Packaging

Memo

0.00

0.00

Packaging

#### Work Order ID 61206

Wednesday, August 11, 2010 10:13:49 AM



Page 4

Item ID:

D3502-1

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Item Name:

Support

8/11/2010

**Start Qty: 12.00** Req'd Qty: 12.00

Operation

Description

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date:

**Tooling:** SPC (Y/N):

Date:

Date:

Run Start



Required Date: 8/25/2010

Sequence ID/ Work Center ID

190

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Number Qty

Stop

Insp. Stamp

Memo

0.00

10/08/3. (L10/8/31

Quality Control

#### **Picklist Print**

Wednesday, August 11, 2010 10:13:48 AM

Work Order ID: 61206

Parent Item Name: Support

D3502-1



**Start Date: 8/11/2010** 

Required Date: 8/25/2010

**Start Qty: 12.00** 

Required Qty: 12.00

Comments:

Parent Item:

IPP Rev:A New Issue 06-07-06 JLM

IPP Rev:B Add tooling hole 07-03-28

Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00		Purchased	No		100	f	77.1000	0.289	3.650526	5		

6061-T6 Bar 1.00 x 4.00

<b>Location</b>	Loc Qty	Loc Code
MAT03	77.1	
107221	58.58	
114352	18.52	

Dart Ae	rospace	Ltd							
W/O:				WORK ORDER	CHANGES				
DATE	STEP		PR	OCEDURE CHANGE	Ву	Date	Qty	Approval - Chief Eng / Prod Mgr	Approval QC Inspector
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								7	
						·			
Part No	): 		PAR #:	Fault Category:	NCR: Ye	es No <b>DQ</b>	A:	Date: _	
	Re	solution:		Disposition:	QA: N/C	Closed:		Date: _	
NCR:				WORK ORDER NON-CON	IFORMANCE (NO	CR)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE STEP	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
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	1									
	1									
		100								
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DART AEROSPACE LTD	Work Order:	61206
Description: Support	Part Number:	D3502-1
Inspection Dwg: D3502 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

	_>	<u> </u>	First Article	Protot	ype
ina			Actual		

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R1.590	+/-0.010	1.590	~		VCIN	SF-12
R1.177	+0.005/-0.000	1.178	1		H-6	31006
0.130	+/-0.010	./30	1		Vern	SF-12
0.080	+/-0.010	.081	1		(/	( )
0.928	+/-0.010	. 923	1		(1	1.7
0.100	+/-0.010	.100	<i>✓</i>	,	\ 1	( )
0.100	+/-0.010	-100	/		11	( )
1.39	^ +/-0.030	1.39	<u></u>		11.	11
		. 3				
					" -	
			•			

Measured by:	Audited by:	13 A	Prototype Approval:	N/A
Date: 15/08/22	Date:	10/08/24	Date:	N/A

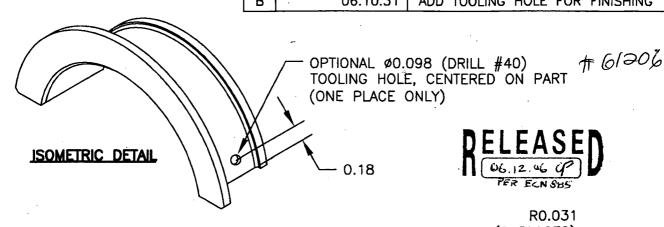
Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM	1
В	07.03.29	Dwg Rev. updated	KJ/JLM X	
	•		7 ()	7,0,7

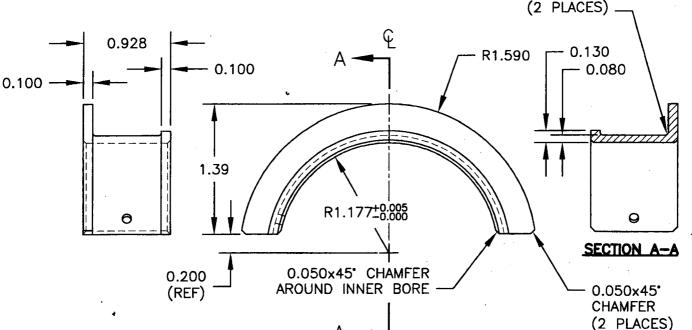
Da	rt .	Aer	os	pac	e L	.td
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W/O:			WO	RK ORDER CHANGE	S					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		†								
Part No		PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	\:	Date:		
Resolu		esolution:	olution: Disposition:			QA: N/C Closed:			Date:	
NCR:		V	ORK ORDE	R NON-CONFORMA	NCE (NCF	R)			· · ·	
DATE	STEP	Description of NC	Corrective Action Sect			Verifica	Verification	Approval	Approval	
		Section A	Initial A Chief Eng	Action Description  Chief Eng	Sign 8 Date	Sectio	ion C	Chief Eng	QC Inspector	
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DESIG	" GP	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	- ,
CHEC	KED ""	APPROVED ,//	DRAWJNG NO. R	EV. B
	#	#	D3602 SHEET 1	OF 1
DATE			TITLE	SCALE
06.1	10.31		SUPPORT	1:1
Α		06.04.18	NEW ISSUE	
R		06 10 31	ADD TOOLING HOLF FOR FINISHING	





## D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ , X.XX =  $\pm 0.030$ ) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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W/O:		# ·	WC	RK ORDER CHANG	ES			
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				:				
Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date:	·
Resolution:			Disposition: QA: N/C			sed:	Date: _	
NCR:		V	ORK ORDI	ER NON-CONFORM	ANCE (NCR	)		
	STEP	Description of NC	Corrective Action Section B		ion B	Verification	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	on Description     Sign &   S	Section C	Chief Eng	QC Inspector
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